Ship foolay

Page 1

Monday, February 28, 2011 11:40:40 AM Accept Item ID: D3512-1 Setup Start Revision ID: Item Name: Wearplate Start Qty: 12.00 Start Date: 2/28/2011 Cust Item ID: Req'd Qty: 12.00 Required Date: 3/4/2011 Customer: Reference: Run Start Date: 1/02-28 Tooling: Process Plan: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Reject Tool # Plan Reject Accept Insp. Work Center ID Description Qty **Run Hours** Code Qty Number Stamp 100 Draw Nbr Revision Nbr Rev C D3512 100 0.00 FLOW WATER JET B11-3-2 Waterjet 0.00 Memo FLOW CNC Waterjet I-Cut as per Dwg D3512 Dwg Rev: Prog Rev: 2-304.063 Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 1B11-3-2 0.00 Memo Quality Control

120

QC

Quality Control

QC8- Inspect parts - second check

0.00 Sulos/v

0.00

Memo

5 ..., 00

(42)

Dart A	Aeros	pace	Ltd
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Dart Ae	rospace Liu							1.5
W/O:			WORK ORDER	CHANGES				. •
DATE	STEP	PRO	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			*					1
Part No):	PAR #:	Fau t Category:	NCR: Yes	No DQ	A:	_ Date: _	
	Resolu	ution:	Disposition:	QA: N/C	Closed:		Date: _	
		,	WORK ORDER NON COL	JEODMANCE (NO	D)			

NCR:		1	WORK ORD	ER NON-CONFORMANO	CE (NCR)			
		Description of NC		Corrective Action Section B			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector

Work Order ID 66831

Monday, February 28, 2011 11:40:40 AM



Page 2

Item ID:

D3512-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Wearplate

2/28/2011 Start Date: Required Date: 3/4/2011

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Tool # Plan

Code

Stop

Reject

Qty

Number Stamp

Insp.

Reject

Sequence ID/

Work Center ID

130

Brake NC

Brake NC

Operation Description

NC BRAKE

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Deburr if necessary Form as per dwg D3512 using DT8179

Tool ID

140

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Accept

Qty

150

Large Fab

Large Fab

Large Fab

Memo

0.00

0.00

Weld hard surface using DT8874 as per Dwg D3512 & QSI 004□Qty Batch A/R 2059b Hardcoat Rod M 117609 Description

EL 115-26

Dart Aerospace Ltd WORK ORDER CHANGES W/O: Approval Approval PROCEDURE CHANGE By Qty DATE STEP Date Chief Eng / QC Inspector Prod Mgr Part No: _____ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Resolution: QA: N/C Closed: _____ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR: Corrective Action Section B Verification Description of NC Approval Approval DATE STEP Sign & Initial **Action Description** Section A Section C Chief Eng QC Inspector Date Chief Eng Chief Eng

Work Order ID 66831

Monday, February 28, 2011 11:40:40 AM



Page 3

Item ID:

D3512-1

Accept

Setup Start

Stop

Revision ID:

Item Name:

Wearplate

Start Date:

2/28/2011

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



Required Date: 3/4/2011

QC:

Date:

SPC (Y/N):

Date:

Tool # Plan

Code

Stop



Sequence ID/

Work Center ID

160

Quality Control

Operation Description

QC10- Inspect visual per QSI004- ground welds

Memo

Set Up/ **Run Hours**

Sulcrize

Tool ID

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

170

Quality Control

QC5- Inspect part completeness to step on W/O

Sul5/20

180

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

m 115128.

Memo

0.00

BL 11-5-26.

Dart Aerospace Ltd WORK ORDER CHANGES W/O: Approval Approval PROCEDURE CHANGE By Qty DATE STEP Date Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Resolution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) NCR: Corrective Action Section B Approval Description of NC Verification | Approval DATE STEP Sign & Action Description

DAIL	SILI	Section A	Chief Eng	Chief Eng	Date	Section C	Chief Eng	QC Inspector

NOTE: Date & initial all entries

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Work Order ID 66831

Monday, February 28, 2011 11:40:40 AM



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Item ID:

D3512-1

Accept

Setup

Run

Start

Stop



Revision ID:

Start Date:

Item Name:

Required Date: 3/4/2011

Wearplate

2/28/2011

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Process Plan:

Date:

Tooling:

Set Up/

Date: Date:

Start

Stop



Approvals:

Sequence ID/

QC:

Date:

SPC (Y/N):

Tool # Plan

Accept

Reject

Insp.

Work Center ID

QC

Quality Control

Operation Description

QC3-Inspect Part Finish

Memo

Run Hours

0.00

0.00

Tool ID

Code

Qty

Qty

Reject Number

Stamp

200

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo



0.00

0.00

11/3/265

210

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dart Ae	rospace	e Ltd								· v
W/O:				V	ORK ORDER CHANGES					. :
DATE	STEP	PRO	CEDUFE	CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No					tegory: No					
NCR:					DER NON-CONFORMANC					
DATE	STEP	Description of NC Section A	Initia Chief		Corrective Action Section B Action Description Chief Eng	Sign	& Secti	cation on C	Approval Chief Eng	Approval QC Inspector
			Chief	ing	Criter Eng	Dat	6			

Picklist Print

Monday, February 28, 2011 11:40:46 AM

Work Order ID: 66831

Parent Item:

D3512-1

Parent Item Name: Wearplate



Start Date: 2/28/2011

Required Date: 3/4/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 06-06-20 JLM

IPP Rev:B Now SS as per Rev B 06-12-15 JLM

IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	39.8400	0.261	3.296842			
										BI	-3-2		

304/316 Sheet .063

Location	Loc Qty	Loc Code	
MAT	39.84		
111323	0		
116623	39.84		116693

	rospace Lt	d						¥ =
W/O:			V	ORK ORDER CHANGE	ES	10011		
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
			8					
Part No		DAD #+	Fourt Co	togony	NCP: Voc	No. DOA:	Date	
Part NO		olution:		tegory:ion:				
NCR:		,	WORK OR	DER NON-CONFORMA	NCE (NCF	R)		
DATE	CTED	Description of NC		Corrective Action Section	SCHOOL STATE	Verification	Approval	Approva
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
							`	

DART AEROSPACE LTD	Work Order:	64831
Description: Wearplate	Part Number:	D3512-1
Inspection Dwg: D3512 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.375	+/-0.010	376	8		V 1302	
12.600	+/-0.010	17,600	u		T 1801	
0.145	+/-0.010	195	×		V	
0.750	+/-0.010	.740	4		V	
2.631	+/-0.010	7.629	8		V	
2.341	+/-0.010	2.349	y		V	
1.240	+/-0.010	1.740	F		V	
0.220	+/-0.010	166.	+		V	
0.380	+/-0.010	1381	×		V	
0.063	+/-0.010	,060	%			
						E

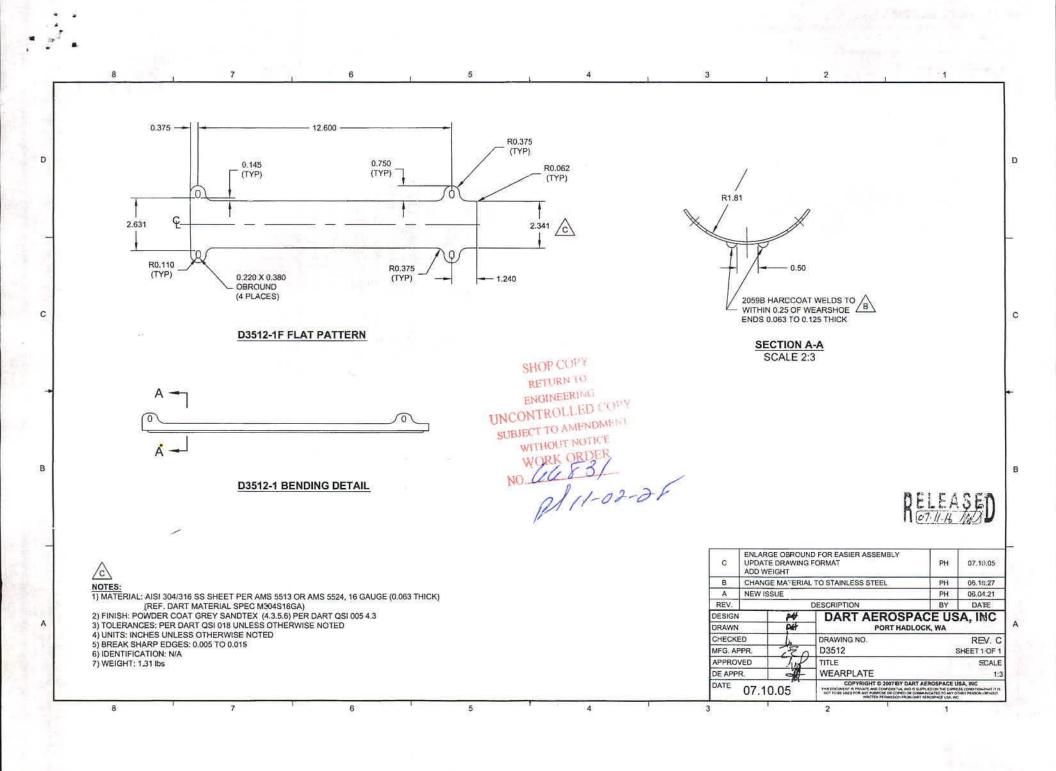
Measured by:	IB	Audited by:	Prototype Approval:	N/A
Date:	11-3-2	Date: 11/3/2	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.04.02	New Issue	KJ/JLM LA	
В	08.01.16	Dimensions updated per Dwg Rev C	KJ/EC/DD	120

Dart Aeros	pace Ltd
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W/O:			W	ORK ORDER CH	ANGES					
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									3,	
Part No:		PAR #:	_ Fault Cat	egory:	NCI	R: Yes I	No DQ	A:	_ Date: _	
	R	esolution:	_ Dispositi	on:	QA: N/C Closed: Date:					
NCR:		W	ORK ORI	DER NON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification		Approval	Approval		
			Initial Chief Eng	Action Descri Chief Eng	otion	Sign & Date	Sect	Section C	Chief Eng	QC Inspector
		1	1 1							

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Dart Aerospace Ltd WORK ORDER CHANGES W/O: Approval Approval DATE STEP PROCEDURE CHANGE By Qty Date Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR: Corrective Action Section B Verification Description of NC Approval Approval STEP DATE **Action Description** Sign & Initia Section C Chief Eng QC Inspector Section A Chief Erg Date Chief Eng